Amendments to the Specification:

Please amend the 6th paragraph on page 3 as follows:

Fig. 5-7 configurations of ~~flattened~~ rough-cast sleeves with a variable sleeve wall thickness and constant depth of the roughened region,

Please amend the 8th paragraph on page 3 as follows:

Fig. 9-11 configurations of ~~flattened~~ rough-cast sleeves having a constant sleeve wall thickness and variable depth of the roughened region,

Please amend the second paragraph on page 4 as follows:

Fig. 13-15 configurations of ~~flattened~~ rough-cast sleeves having a variable sleeve wall thickness, constant depth of the roughened region, and without rough-cast structures on the outer surfaces of those sleeve regions that lie opposite one another in the case of the rough-cast sleeves combined to form sleeve packages, ~~and are flattened,~~

Please amend the third paragraph on page 4 as follows:

Fig. 16 two rough-cast sleeves joined together ~~by way of their flattened regions~~,

Please amend the second paragraph on page 6 as follows:

The ~~flattened~~ rough-cast sleeves shown in cross-section in Figures 5 to 15. The sleeves have two contact regions that lie opposite one another and reach over their entire axial length. In other words, the contact regions are regions where the rough-cast sleeves contact each other. The radially outer surface of the contact regions have a lesser radial distance from the longitudinal axes of the sleeves than the radially outer surface of the other two regions. The rough cast sleeves can consist of cast iron and are then preferably produced using the spin casting method. However, they can also consist of an aluminum-silicon alloy, which opens up the possibility of producing the rough-cast sleeves using the gravity casting method, the spin casting method, or the "lost-foam" casting method. Finally, there is the possibility of producing the rough-cast sleeves from a sintered metal. In this connection, the sleeves can already obtain their final shape, ~~flattened on one or two sides~~, within the framework of the casting process. However, there is

also the possibility of ~~flattening~~ shaping the sleeves after casting, such as shown in FIGS. 5-15, by means of mechanical machining (milling).

Please amend the paragraph spanning pages 6-7 as follows:

In the production of an engine block from light metal, such as, for example, from aluminum, magnesium, or an alloy of these metals, there is the possibility, for one thing, of setting the sleeves onto spindle sleeves of the casting mold, orienting them in such a manner that ~~that~~ the ~~flattened~~ contact regions of the sleeves lie against one another, and then casting the light metal of the engine block around them. For another thing, the sleeves can be joined to one another by way of their ~~flattened~~ contact regions, i.e. welded, soldered, or glued to one another by way of the ~~flattened~~ mantle surfaces of the contact area, so that eyeglass-shaped arrangements of the sleeves result, in cross-section. The sleeve packages obtained in this manner are then laid into the casting mold and the light metal of the engine block is cast around them.

Please amend the last paragraph on page 7 as follows:

Fig. 6: A sleeve 16 having a variable thickness of the sleeve wall 19′, with a constant depth of the roughened region 20, and an outer shape that consists of four arc-shaped segments 21 to 24 of approximately equal size, whereby thicker regions of the sleeve wall 19′ delimit the segments 21 and 22 that lie opposite one another, and thinner regions of the sleeve wall 19′, ~~i.e. its flattened regions,~~ delimit the segments 23 and 24 that lie opposite one another, towards the outside, is shown.

Please amend the second and third paragraphs on page 8 as follows:

Fig 7: A sleeve 17 having a variable thickness of the sleeve wall 19″, with a constant depth of the roughened region 20 and an outer shape that is composed, in cross-section, of two arc-shaped segments 25 and 26 that lie opposite one another, and two ~~flat~~ <u>contact</u> segments 27 and 28 that like opposite one another, is shown. In this connection, the ~~flattened~~ <u>contact</u> regions of the sleeve 17 that lie opposite one another are delimited, towards the outside, by the segments 27 and 28.

Fig. 8 shows a possibility of disposing the rough-cast sleeves 15 having an elliptical contour next to one another, in space-saving manner, so that a sleeve package 18 that is suitable for a four-cylinder engine is obtained. In this connection, the regions of the elliptical contour next to the axis delimit the ~~flattened~~ <u>contact</u> regions of the sleeves 15, which ~~flattened~~ regions lie at a distance opposite one another in the arrangement of the sleeves 15 to form a sleeve package 18.

Please amend the second, third and fourth paragraphs on page 10 as follows:

Fig. 13: A sleeve 35 having a variable sleeve wall thickness, constant depth of the roughened region, and an elliptical outer contour, which is the same as the outer contour of the sleeve 15 shown in Fig. 5, is shown. In this connection, the ~~flattened~~ <u>contact</u> sleeve regions 38 and 39 that lie opposite one another do not have any rough-cast structures.

Fig. 14: A sleeve 36 having a variable sleeve wall thickness, constant depth of the roughened region, and an outer contour consisting of several arc-shaped segments, in cross-

section, which contour is the same as the outer shape of the sleeve 16 shown in Fig. 6, is shown. The ~~flattened~~ contact sleeve regions 40 and 41 that lie opposite one another do not have any rough-cast structures.

Fig. 15: A sleeve 37 having a variable sleeve wall thickness, constant depth of the roughened region, and an outer contour consisting of two arc-shaped and two flat segments, in cross-section, which contour is the same as the outer shape of the sleeve 17 shown in Fig. 7, is shown. In this connection, if the sleeve is the first or last element of a sleeve package disposed in a row, a ~~flat~~ segment 43 of the outer contour can be provided with a rough-cast structure, and the segment 42 that lies opposite the former can be configured without a rough-cast structure. In this connection, those segments 38 to 42 of the outer contours of the rough-cast sleeves 35 to 37 that have no rough-cast structures can already be produced within the framework of the casting process. However, it is also possible to provide the entire mantle surface of the sleeve with a rough-cast structure and to subsequently mill away the rough-cast structures of the sleeve contact regions~~ to be flattened~~.

Please amend the second paragraph on page 11 as follows:

The sleeves 17, 31, and 37 shown in Fig. 7, 11, and 15, the outer contours of which have the ~~flat~~ segments 27, 28, 42, and 43, can be joined to one another by way of these segments, by means of gluing, soldering, or welding, so that sleeve structures that are eyeglass-shaped in cross-section result. This brings with it the advantage that in the production of engine blocks, several sleeves can be placed into the casting machine at the same time, thereby accelerating the production of the engine blocks and making it less expensive. According to Fig. 16, a glue or solder layer 44, in each instance, is applied to the opposite ~~flattened~~ region of the sleeves, in this connection, before the sleeves are joined together.

Please amend the second paragraph on page 14 as follows:

Another solution for the problem of keeping the ~~flattened regions~~ <u>contact areas</u> of the rough-cast sleeves at a distance and of ensuring that the sleeves are disposed in a clearly defined position of rotation relative to one another consists, according to Fig. 25 and 26, of a spacer 62 disposed between the ~~flattened~~ <u>contact</u> regions 63 and 64. This has the additional

advantage that space is available between the ~~flattened~~ contact regions 63 and 64 of the sleeves being held at a distance from one another, for cooling bores to be made in the engine block.

Please amend the reference number list on pages 15-16 as follows:

Reference Symbol List

x land width

y depth of the roughened region

z distance between two rough-cast sleeves

1 to 4 rough-cast sleeve

5 sleeve package

6 to 8 wall region

9, 10 cross-section

11, 12 elevation

13, 14 undercut

15 to 17 sleeve, cylinder sleeve

18 sleeve package

19, 19′ 19″ sleeve wall

20 roughened region

21 to 24 segment of the outer shape of the sleeve 16

25 to 28 segment of the outer shape of the sleeve 17

29 to 31 sleeve, cylinder sleeve

32 sleeve wall

33, 33′, 33″ roughened region

34 sleeve package

35 to 37 sleeve, cylinder sleeve

38, 39 ~~flattened~~ <u>contact</u> region of the sleeve 35

40, 41 ~~flattened~~ <u>contact</u> region of the sleeve 36

42, 43 segment of the outer contour of the sleeve 37

44 adhesive or solder layer

45, 45′, 46, 46′ bridge

47 to 50 face

51, 52 sleeve, cylinder sleeve

53, 53′ step

55, 54′ flattened region of the step 53

55 gap width

56 wall thickness

57 depth of the roughened region

58 cylinder diameter

60 land width

61 ~~flattened~~ <u>contact</u> region

62 spacer

63, 64 ~~flattened~~ contact region